

Work Order ID 86742

86742

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July-06-12 11:49:45 AM

Item ID: D3224-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Frame
 Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-11 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3224	Rev A					(6)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3224 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-								
<u>254 267</u>	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

1812-7-24

P/h

1812-7-24

5mB
12-7-24

DAS
16
2-83
12/14/24

(6)

8

W/O: 86742

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3224-1 PAR #: _____ Fault Category: Water jet NCR: Yes No DQA: full Date: 12/09/01
 Resolution: _____ Disposition: Swap QA: N/C Closed: cl Date: 12/8/2

NCR: <u>12-1644</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>\$10.46</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12/12/24</u>	<u>#100</u>	Found at inspection that Qty x1 was too short. 25.375 should be 25.500. RC water jet operator tried to fit as much in one sheet as possible operator error	<u>DAS</u> <u>16</u> <u>2-8</u> <u>052042</u> <u>17/09/24</u>	<u>SCRAP + Destroy qty x1</u> <u>And Replace</u> <u>2524T3-0.063 in 12/19</u>	<u>12-9-21</u>	<u>DAS</u> <u>16</u> <u>2-8</u> <u>12/12/24</u>	<u>DAS</u> <u>16</u> <u>2-8</u> <u>052042</u> <u>12/09/24</u>	<u>DAS</u> <u>16</u> <u>2-8</u> <u>12/07/24</u>

NOTE: Date & initial all entries

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 Required Date: 8/03/12 Req'd Qty: 6.00 ***6*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00		n/b					
Small Fab	Deburr								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00				6			S 12/07/25
Brake NC	Form as per Dwg D3224								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DAS
16
2-83

12/07/25

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July-06-12 11:49:45 AM

Item ID: D3224-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Frame

Start Date: 7/06/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

6x 7/6 12-7-26

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

6x 12-7-27

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

6x 12-7-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/7/30

MF
1207-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86742

Parent Item: D3224-1

Parent Item Name: Frame

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	243.8900	5.2	32.842105 64,		B/L-7-24	
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT022		243.89					
						119916		71.35					
						121197		172.54					
										121197			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

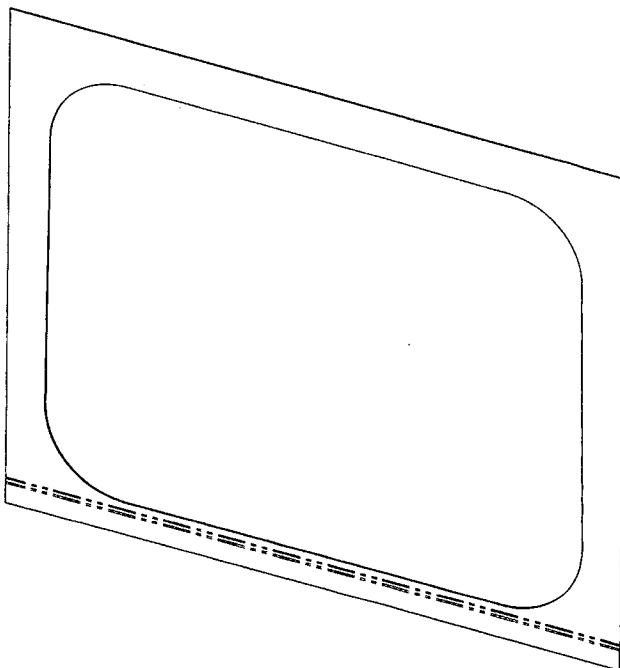
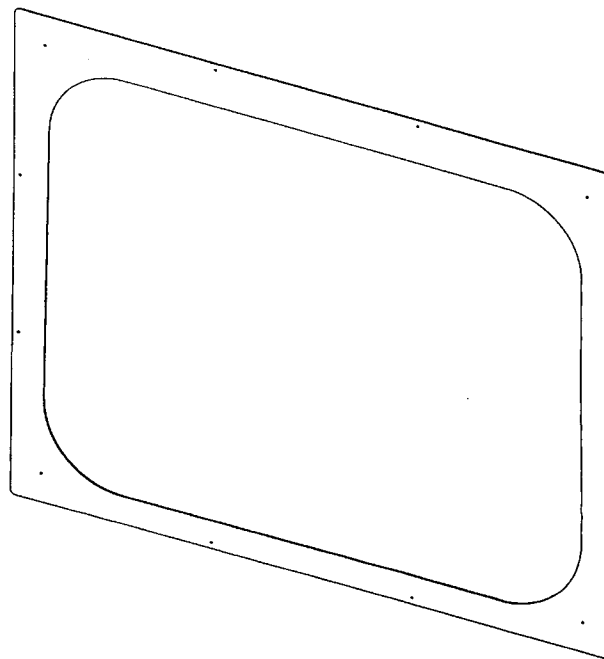
5

4

3

2

1

**D3224-1 FRAME****D3224-3 FRAME**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86742

AD-07-4

RELEASED
09/05/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037
REF. DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3224-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3224-1 = 1.40 lbs
D3224-3 = 1.22 lbs

B	REDRAWN TO CURRENT DRAWING STANDARDS: ADDED D3224-1F AND D3224-3. REASON: SEE NCR#09-054.	MB	09.05.07
A	NEW ISSUE	RF	03.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>41</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>41</u>		
CHECKED	<u>41</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>41</u>	D3224	SHEET 1 OF 3
APPROVED	<u>41</u>	TITLE	SCALE
DE APPR.	<u>41</u>	FRAME	NTS
DATE	09.05.07	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

